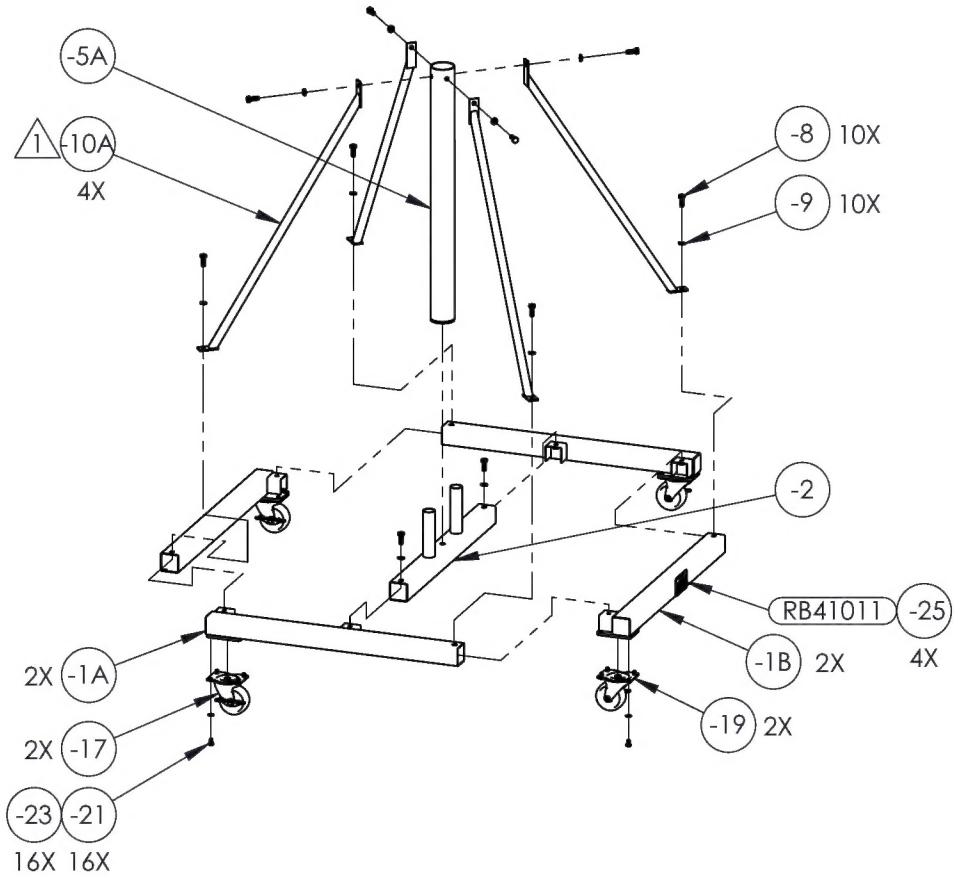
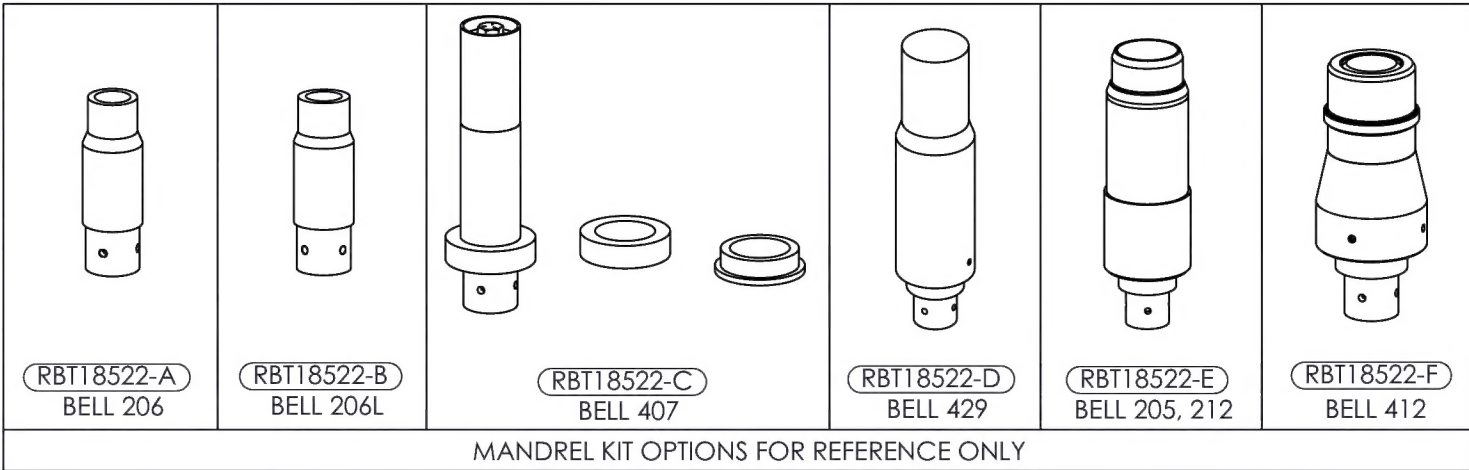


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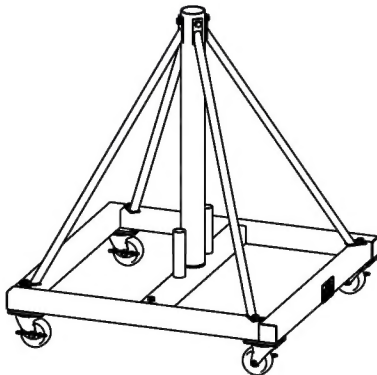
ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-1A	2	SIDE BASE WELDMENT			2
				1		-1A-1		BASE TUBE	STEEL SQ. TUBE		3
			X			-1B	2	END BASE WELDMENT			4
			1			-1B-1		BASE TUBE	STEEL SQ. TUBE		5
		X				-2	1	CENTER BASE WELDMENT			6
		1				-2A		CENTER BASE TUBE	STEEL SQ. TUBE		7
		2				-2B		TOOL HOLDER	STEEL TUBE		8
			1	2		-3		CLIP	A36/1018/1020 HR		9
			1	2	B/O	-4		WELDNUT	STEEL	3/8-16 UNC (MCMaster-CARR #93560A160)	2,4
X						-5A	1	VERTICAL WELDMENT			10
1						-5		VERTICAL TUBE	STEEL TUBE		11
1						-6		BOTTOM CAP	1018/1020 CR		12
					B/O	-8	10	HEX HEAD CAP SCREW	STEEL	3/8-16 UNC X 1 (MCMaster-CARR #92865A624)	1
					B/O	-9	10	SPLIT RING LOCK WASHER	STEEL	Ø3/8 (MCMaster-CARR #91102A760)	1
X						-10A	4	BRACE WELDMENT			13
1						-10		BRACE TUBE	STEEL SQ. TUBE		14
1						-11		BOTTOM BRACE TAB	A36/1018/1020 HR		15
	1				B/O	-12		DOWEL PIN	STEEL	Ø1/2 X 3/4 (MCMaster-CARR #98381A710)	10
1						-13		UPPER BRACE TAB	A36/1018/1020 HR		16
				1	1	-14		END CAP	A36/1018/1020 HR		17
				1	1	-15		WHEEL PLATE	A36/1018/1020 HR		18
					B/O	-17	2	3 in SWIVEL CASTER W/BRAKE		[GALIFCO #2.03356-92 BRK1]	1
					B/O	-19	2	3 in RIGID CASTER		[GALIFCO #2.03308-92]	1
					B/O	-21	16	BUTTON HEAD CAP SCREW	S.S.	5/16-18 X 1/2 (MCMaster-CARR #92949A578)	1
					B/O	-23	16	INTERNAL LOCK WASHER	S.S.	Ø5/16 (MCMaster-CARR #91757A111)	1
					B/O	-25	4	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMaster-CARR #90081A077)	1
					B/O		1	PLACARD	ALUMINUM	RB41011	1
ASSY -10A	ASSY -5A	ASSY -2	ASSY -1B	ASSY -1A							

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 S.F. WAS Ø2.265 & IS NOW S.F. Ø2.250.	4/29/2008	WP	GE
2		IMPLEMENTED NEW DWG. FORMAT, ADDED WELDMENT PART NUMBERS AND PLACED WELDMENTS ON ONE PAGE, ADDED MISSING VIEWS FOR CLARITY, & CONDENSED FROM 9 Pg.'s TO 3.	5/27/2008	WP	RW
3		CH'D P/N -3 OVERALL LENGTH FROM 4.872 & DIM TO FIRST FOLD LINE FROM 1.605 PER W.P.	10/27/2009	RJC	RW
4	14-0140	UPDATED TO NEW DRAFTING STANDARDS. CH'D TITLE BLOCK WAS RED BARN IS DART. -2 ADDED PARTS -2A & -2B, -2A WAS -2. -2A WAS -2, CH'D DIM WAS Ø.500 THRU IS LIMITS Ø.502 TO .505 .10. -3 CH'D B/O INFO WAS 14ga. X 1-1/2 X 4-7/8 IS 14ga. X 1-5/8 X 5-1/8. -4 ADDED B/O INFO #93560A160. -6 CH'D DIM WAS Ø.500 P.F. -12 IS LIMITS Ø.4989 TO .4996. -8 ADDED B/O INFO #92865A624. -9 ADDED B/O INFO #91102A760. -10 CH'D B/O INFO WAS X 33 IS X 31. CORRECTED DIM FROM 1.00 TO (.75). BOM WAS CORRECT. -11 CH'D B/O INFO WAS 1/8 X 1 X 2 IS 1/8 X 1-1/8 X 2-1/8. -12 CH'D TO B/O, ADDED B/O INFO #98381A710. -13 CH'D B/O INFO WAS 1/8 X 1 X 2-3/4 IS 1/8 X 1 X 2-7/8. MOVED ALL PARTS TO SEPARATE SHEETS. ADDED KIT B, C, & CASTERS.	8/21/2014	DPD	JAG
5	14-0178	BROKE OUT MANDREL KITS & RE-NUMBERED WAS RBT18522-7 IS RBT18522-A, WAS RBT18522-25 IS RBT18522-B, WAS RBT18522-27 IS RBT18522-C. ADDED ASSEMBLY NOTE FOR -10A, -1A & -1B ADDED -14 TO WELDMENT. -1 REPLACED BY -1A-1 & -1B-1. -1A-1 ADDED DRAWING. -2A CH'D DIMS WAS 2X Ø.405 .10 HOLES IS 2X .41. 2X .19 .10. 4X FULL R SLOTS. WAS .75 IS .66. WAS .75 IS .66. -3 CH'D DIM WAS 1.68 IS 1.68+.03. -10A ADDED DIMS 1.11 & 1.36. -14 CH'D END CAP WAS B/O PLASTIC OUTWATER #T64-U-2-BLK IS IN HOUSE A36.083 X 2-1/8 X 2-1/8, ADDED DWG. -17 CH'D B/O INFO WAS APPLIED INDUSTRIAL (MFG MCT) #2F9803B25002100 IS GALIFCO #2.03356-92. -19 CH'D B/O INFO WAS APPLIED INDUSTRIAL (MFG MCT) #1F9803B25002100 IS GALIFCO #2.03308-92.	10/13/2014	DPD	JAG
6	15-0062	ADDED RBT18522-D MANDREL KIT OPTION FOR BELL 429.	3/16/2015	RJC	JAG
7	16-0199	ADDED 205, 212, 412 TO USED ON MODELS. ADDED RBT18522-E, RBT18522-F TO MANDREL KIT OPTIONS. -1A, -1A-1, -1B, -1B-1, -2, -2A, -2B, -3, -5A, -10A, -10, -11, -13, -14, -15 CH'D TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03. -1A, -1B ADDED MISSING WELD SYMBOLS. ADDED DIM 2.13 NO WELD. -1A-1, -1B-1 CH'D DIMS WAS Ø.405 .10 IS .405 .10. WAS 3X Ø.38 .10 IS 3X Ø.38 .10. WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) IS .08. ADDED DIMS .13, 2X FULL R. -2A CH'D DIMS WAS 2X .41 IS 2X .41 .10. WAS Ø.502-.505 .10 IS Ø.502-.505 .10. WAS 2X .19 .10 IS 2X .19 .10. WAS (2.00) IS .08, WAS (2.00) IS 2.00, WAS (.083) IS .08. -2B CH'D MAT'L WAS ERW IS STEEL TUBE. CH'D DIMS (.083) IS .08, WAS (Ø1.25) IS Ø1.25. -3 CH'D DIM WAS 1.68 IS 2X 1.68, WAS .075 IS .08. -3, -11, -13 CH'D MAT'L WAS 1018 IS A36/1018/1020 HR. -5 CH'D DIMS WAS (Ø2.50) IS Ø2.50, WAS (.120) IS .12, WAS 4X Ø.406 .13, EQUALLY SPACED IS 2X Ø.406 THRU ALL EQUALLY SPACED, WAS 4X 1.00 IS 2X 1.00, ADDED DIMS Ø2.26-2.27 (S.F.-6), Ø2.26-2.27, 2.03, .25. CH'D MAT'L WAS DOM IS STEEL TUBE. -6 CH'D DIMS WAS (Ø2.50) IS Ø2.50, WAS Ø2.25 S.F.-5 IS Ø2.24-2.25 (S.F.-5). CH'D MAT'L WAS 1018/1020 IS 1018/1020 CR. -10 CH'D DIMS WAS (.75) IS .75, WAS (.75) IS .75, WAS (.083) IS .08. -11, -13 CH'D DIMS WAS (1.00) IS 1.00, WAS (.125) IS .13, WAS Ø.39 THRU ALL IS .391 THRU ALL. CH'D MAT'L WAS 1018 IS A36/1018/1020 HR. -14 CH'D DIM WAS (.083) IS .08. -14, -15 CH'D MAT'L WAS A36 IS A36/1018/1020 HR. -15 CH'D DIMS WAS (.250) IS .25, WAS 2X 3.00 IS 2X 3.000, WAS 2X 1.75 IS 2X 1.750. -17 CH'D B/O REF WAS #2.03356-92 IS (#2.03356-92 BRK1). -19 CH'D DESCRIPTION WAS 3 in RIGID CASTER W/BRAKE IS 3 in RIGID CASTER. -25 ADDED TO BOM QTY 4. RB41011 ADDED TO BOM.	10/31/2016	DPD	SM



#### NOTES:

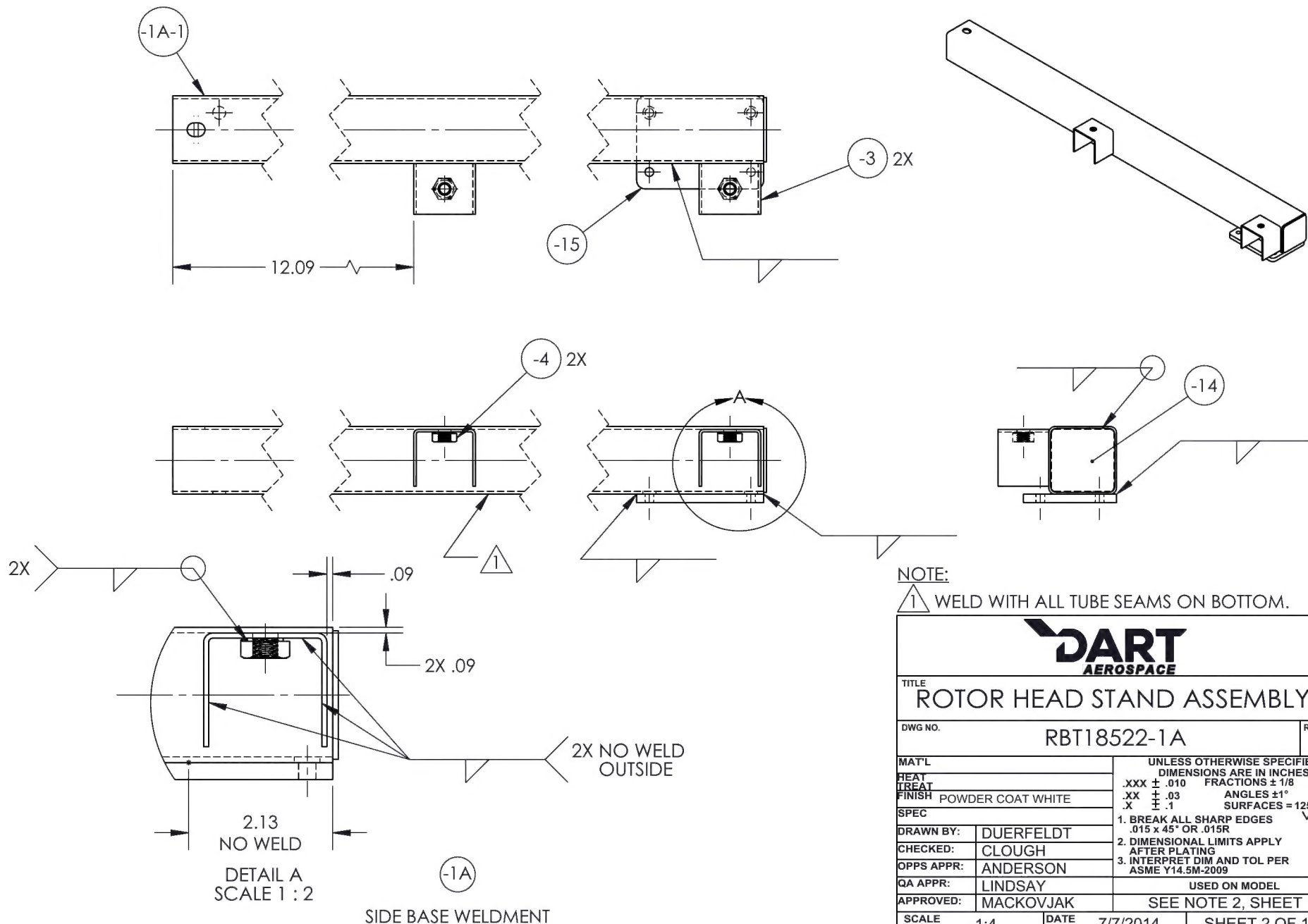
- 10A BRACE WELDMENT ATTACHES WITH THE -11 BOTTOM BRACE TAB END TOWARD THE -1A & -1B WELDMENTS.
- USED ON MODELS:  
BELL 205, 206, 206L, 212, 407, 412



DART AEROSPACE		
TITLE ROTOR HEAD STAND ASSEMBLY		
DWG NO. RBT18522	REV 7	
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 ANGLES ± .5° SURFACES = 125✓	
DRAWN BY: CHECKED: OPPS APPR: QA APPR:	DUERFELDT CLOUGH ANDERSON LINDSAY	
APPROVED: SCALE	MACKOVJAK 1:20	
DATE	7/7/2014	
SHEET 1 OF 19	USED ON MODEL SEE NOTE 2	


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-1A ADDED -14 TO WELDMENT.	10/14/2014	DPD	JAG
7	16-0199	-1A ADDED MISSING WELD SYMBOLS. ADDED DIM 2.13 NO WELD. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	10/31/2016	DPD	SM



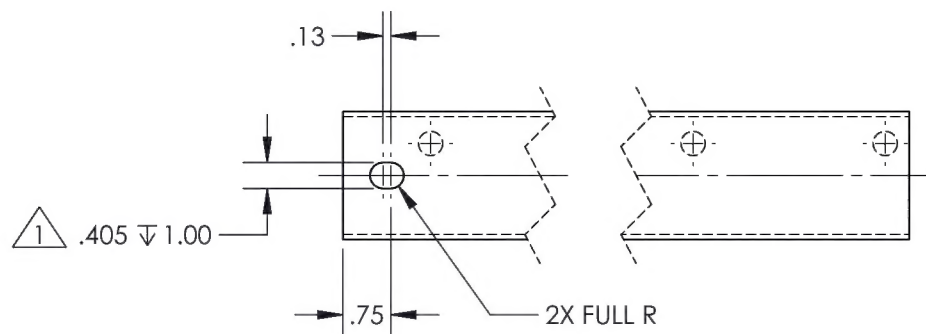
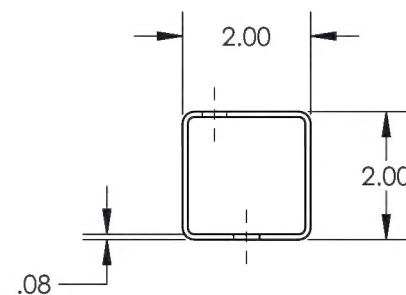
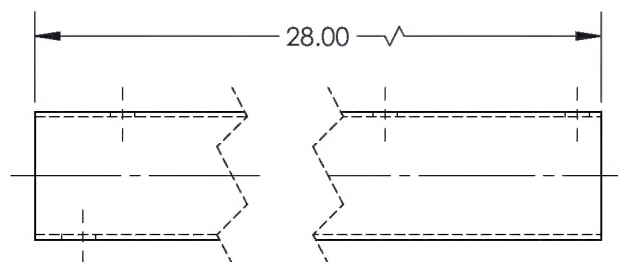
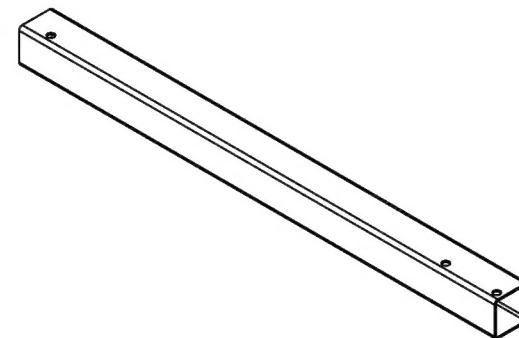
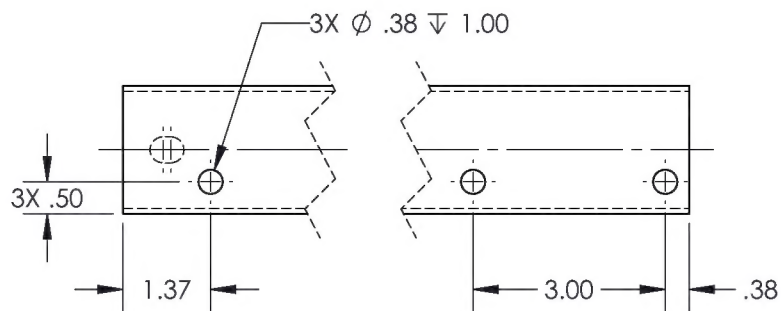
NOTE:

1 WELD WITH ALL TUBE SEAMS ON BOTTOM.

			
TITLE ROTOR HEAD STAND ASSEMBLY			
DWG NO. RBT18522-1A			REV 7
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
HEAT TREAT			
FINISH POWDER COAT WHITE			
SPEC			
DRAWN BY: DUERFELDT			
CHECKED: CLOUGH		USED ON MODEL SEE NOTE 2, SHEET 1	
OPPS APPR: ANDERSON			
QA APPR: LINDSAY			
APPROVED: MACKOVJAK			
SCALE 1:4	DATE 7/7/2014	SHEET 2 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-1A-1 ADDED DRAWING.	10/14/2014	DPD	JAG
7	16-0199	-1A-1 CH'D DIMS WAS Ø.405 $\nabla$ 1.10 IS .405 $\nabla$ 1.00, WAS 3X Ø.38 $\nabla$ 1.10 IS 3X Ø.38 $\nabla$ 1.00, WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) IS .08. ADDED DIMS .13, 2X FULL R. CH'D TOLERANCES WAS $\pm$ .005 IS $\pm$ .010, WAS $\pm$ .01 IS $\pm$ .03.	10/31/2016	DPD	SM



(1A-1)

BASE TUBE

NOTE:

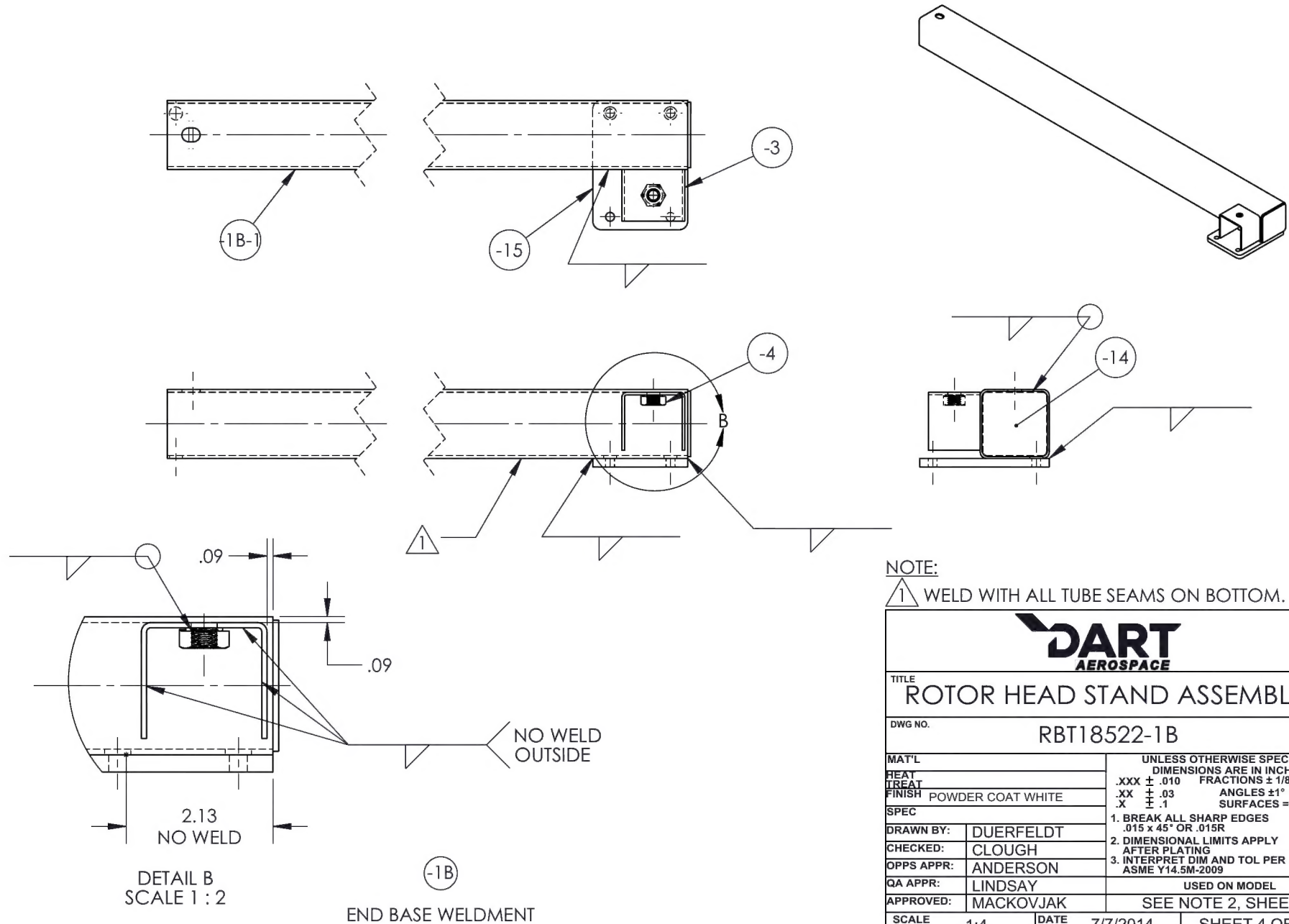
1 HOLE ON TOP, SEAM ON BOTTOM.

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-1A-1</b>	REV <b>7</b>
MAT'L STEEL SQ. TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1A	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .03 ANGLES $\pm$ 1°
DRAWN BY: DUERFELDT	.X $\pm$ .1 SURFACES = 125✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:3	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/7/2014	USED ON MODEL
SHEET 3 OF 19	SEE NOTE 2, SHEET 1



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-1B ADDED -14 TO WELDMENT.	10/14/2014	DPD	JAG
7	16-0199	-1B ADDED MISSING WELD SYMBOLS. ADDED DIM 2.13 NO WELD. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	10/31/2016	DPD	SM



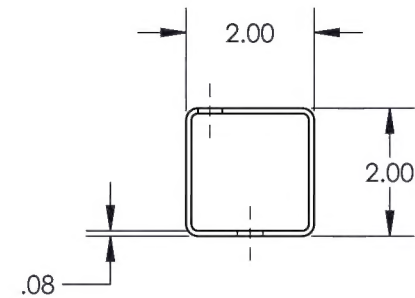
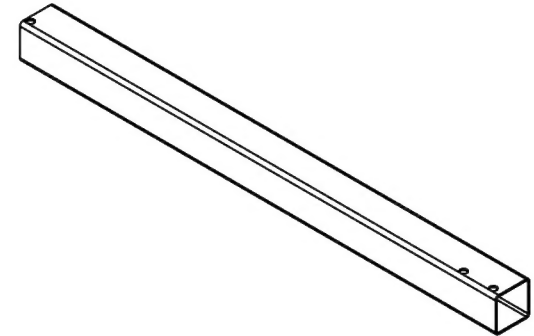
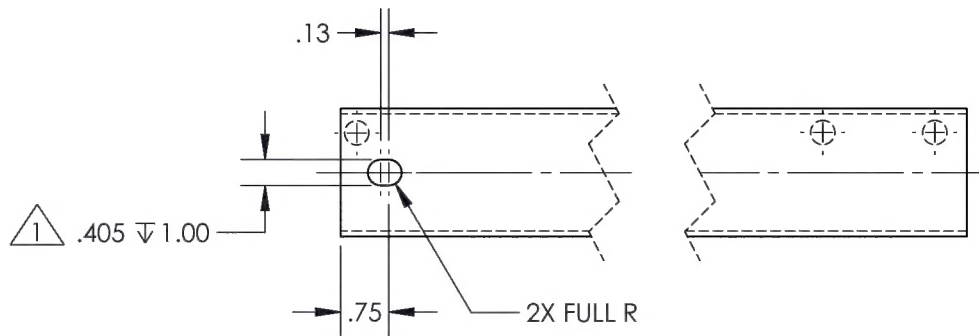
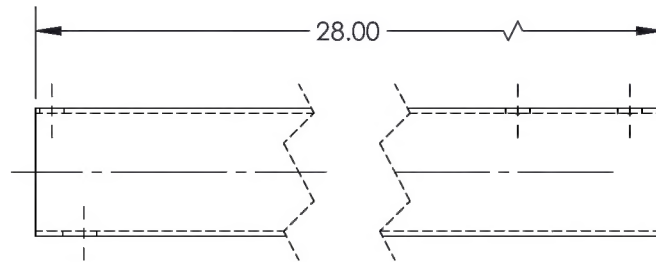
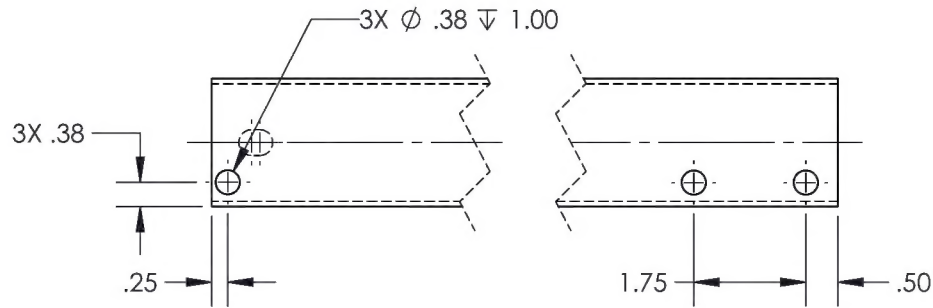
NOTE:

1 WELD WITH ALL TUBE SEAMS ON BOTTOM.

			TITLE	
			ROTOR HEAD STAND ASSEMBLY	
DWG NO.		RBT18522-1B		REV 7
MAT'L		UNLESS OTHERWISE SPECIFIED		
TREAT		DIMENSIONS ARE IN INCHES		
FINISH		.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8		
SPEC		.XX $\pm$ .03 ANGLES $\pm$ 1°		
DRAWN BY:		.X $\pm$ .1 SURFACES = 125°		
CHECKED:		1. BREAK ALL SHARP EDGES		
OPPS APPR:		.015 x 45° OR .015R		
QA APPR:		2. DIMENSIONAL LIMITS APPLY		
APPROVED:		AFTER PLATING		
SCALE		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
DATE		USED ON MODEL		
7/7/2014		SEE NOTE 2, SHEET 1		
1:4		SHEET 4 OF 19		

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-1B-1 ADDED DRAWING.	10/14/2014		
7	16-0199	-1B-1 CH'D DIMS WAS Ø.405 $\nabla$ .10 IS .405 $\nabla$ 1.00, WAS 3X Ø.38 $\nabla$ .10 IS 3X Ø.38 $\nabla$ 1.00, WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) IS .08. ADDED DIMS .13, 2X FULL R. CH'D TOLERANCES WAS $\pm$ .005 IS $\pm$ .010, WAS $\pm$ .01 IS $\pm$ .03.	10/31/2016	DPD	SM



NOTE:

1 HOLE ON TOP, SEAM ON BOTTOM.

**DART**  
AEROSPACE

TITLE  
ROTOR HEAD STAND ASSEMBLY

DWG NO. RBT18522-1B-1 REV 7

MAT'L STEEL SQ. TUBE

HEAT TREAT SEE -1B WELDMENT

FINISH SEE -1B WELDMENT

SPEC

DRAWN BY: DUERFELDT

CHECKED: CLOUGH

OPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: MACKOVJAK

SCALE 1:3 DATE 7/7/2014 SHEET 5 OF 19

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

.XXX  $\pm$  .010 FRACTIONS  $\pm$  1/8

.XX  $\pm$  .03 ANGLES  $\pm$  1°

.X  $\pm$  .1 SURFACES = 125°

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

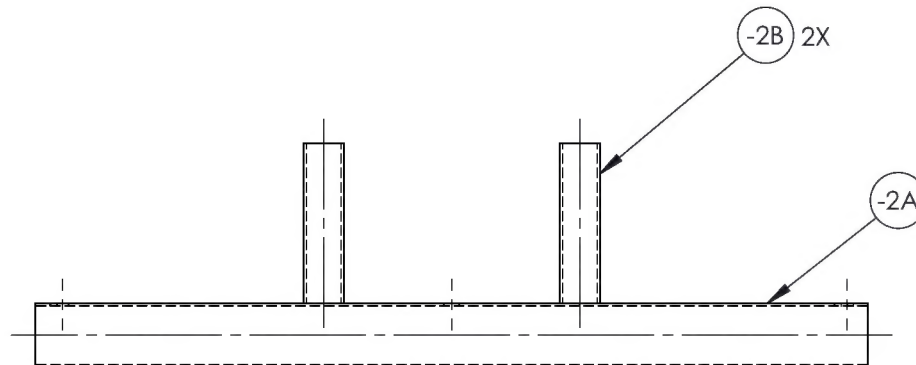
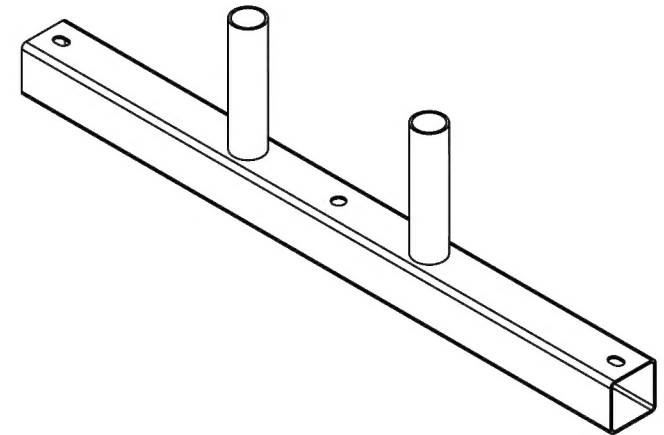
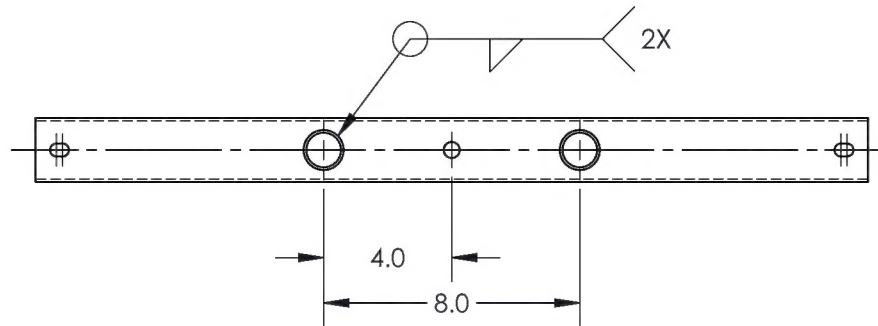
AFTER PLATING

3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

(-1B-1)  
BASE TUBE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0140	ADDED -2A & -2B, 2A WAS -2	8/26/2014	JAG	DW
7	16-0199	-2 CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	11/22/2016	DPD	SM



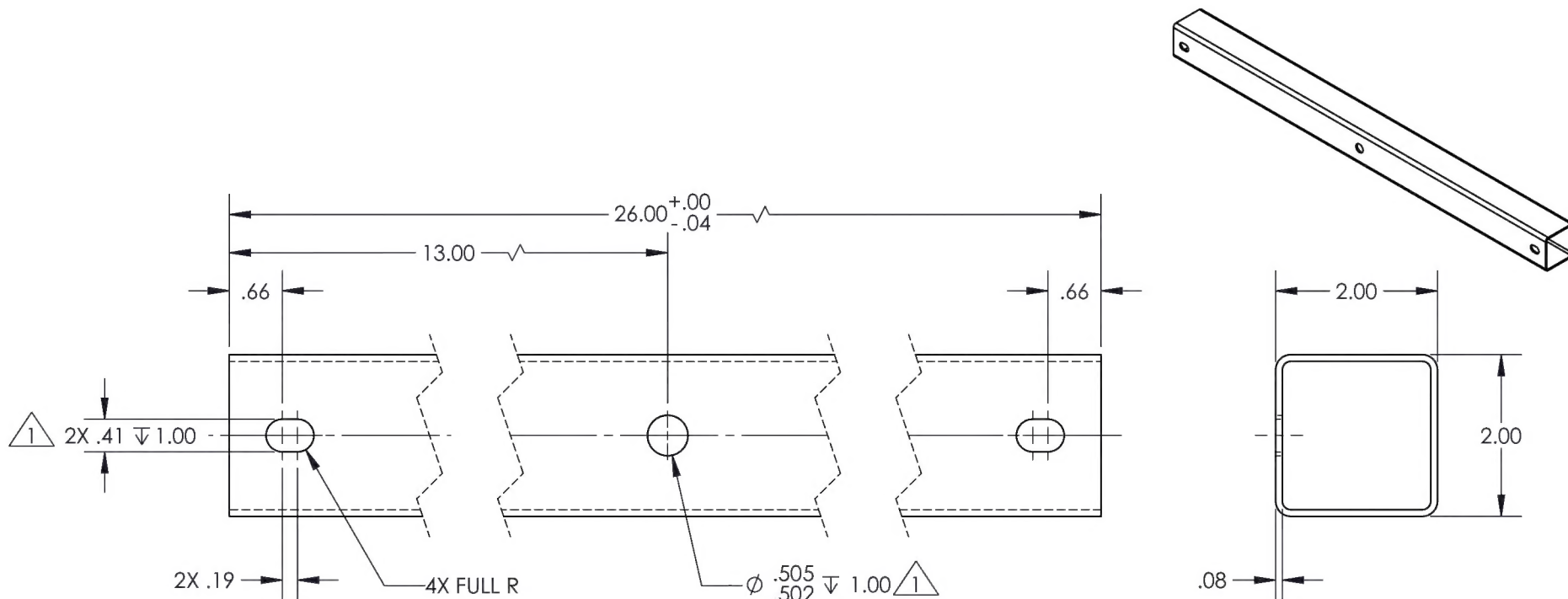
(2)

CENTER BASE WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-2</b>	REV <b>7</b>
MAT'L <b>ALUMINUM 6061-T6</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT <b>POWDER COAT WHITE</b>	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
FINISH <b>POWDER COAT WHITE</b>	.XX $\pm$ .03 ANGLES $\pm$ 1°
SPEC <b>POWDER COAT WHITE</b>	.X $\pm$ .1 SURFACES = 125✓
DRAWN BY: <b>GILBERT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: <b>ANDERSON</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>MACKOVJAK</b>	SEE NOTE 2, SHEET 1
SCALE <b>1:6</b>	DATE <b>8/25/2014</b>
SHEET 6 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0140	-2A WAS -2, CH'D DIM WAS Ø.500 THRU IS LIMITS Ø.502 TO .505 $\nabla$ .10 .	7/8/2014	DPD	JAG
5	14-0178	-2A CH'D DIMS WAS 2X Ø.405 $\nabla$ .10 HOLES IS 2X .41, 2X .19 $\nabla$ .10, 4X FULL R SLOTS, WAS .75 IS .66, WAS .75 IS .66.	10/14/2014	DPD	JAG
7	16-0199	-2A CH'D DIMS WAS 2X .41 IS 2X .41 $\nabla$ 1.00, WAS Ø.502-.505 $\nabla$ .10 IS Ø.502-.505 $\nabla$ 1.00, WAS 2X .19 $\nabla$ .10 IS 2X .19, WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) IS .08, CH'D TOLERANCES WAS $\pm$ .005 IS $\pm$ .010, WAS $\pm$ .01 IS $\pm$ .03.	10/31/2016	DPD	SM



NOTE:

1 HOLES ON TOP, SEAM ON BOTTOM.



TITLE  
ROTOR HEAD STAND ASSEMBLY

DWG NO. RBT18522-2A

REV  
7

MAT'L STEEL SQ. TUBE

HEAT TREAT  
FINISH SEE -2 WELDMENT

SPEC

DRAWN BY: DUERFELDT

CHECKED: CLOUGH

OPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: MACKOVJAK

SCALE 1:2

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

.XXX  $\pm$  .010 FRACTIONS  $\pm$  1/8

.XX  $\pm$  .03 ANGLES  $\pm$  1°

.X  $\pm$  .1 SURFACES = 125  $\sqrt$

1. BREAK ALL SHARP EDGES

.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

SEE NOTE 2, SHEET 1

DATE 7/7/2014

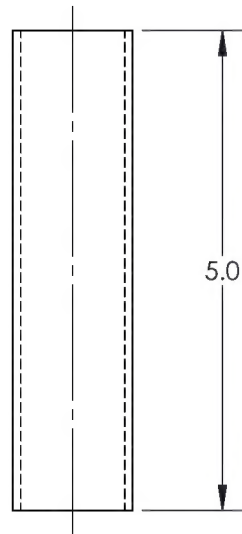
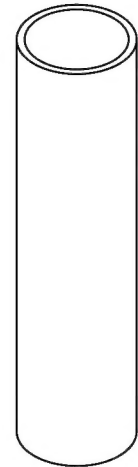
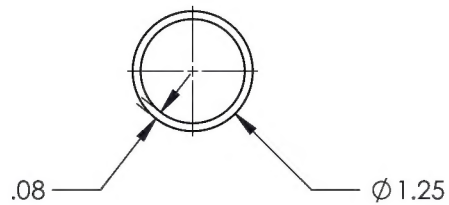
SHEET 7 OF 19

(-2A)

CENTER BASE TUBE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0140	ADDED THIS PART	8/26/2014	JAG	DW
7	16-0199	-2B CH'D MAT'L WAS ERW IS STEEL TUBE. CH'D DIMS (.083) IS .08, WAS (Ø1.25) IS Ø1.25. CH'D TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03.	10/31/2016	DPD	SM



(-2B)

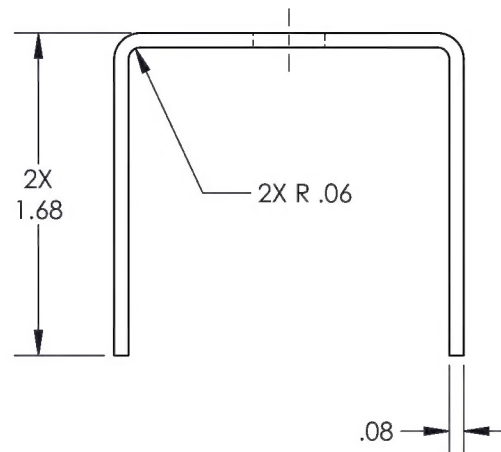
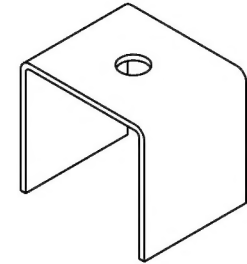
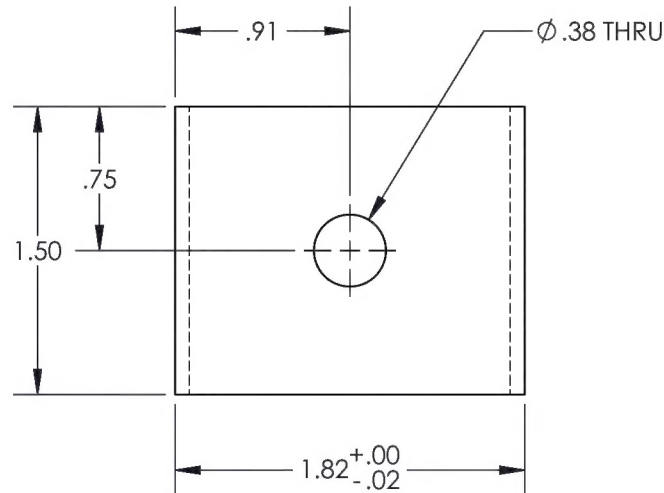
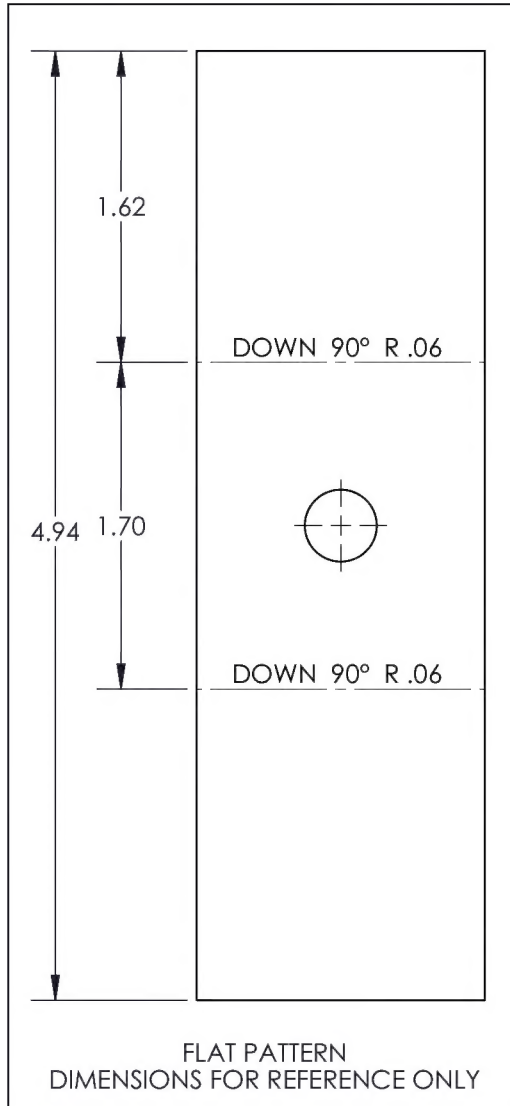
TOOL HOLDER

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-2B</b>	REV <b>7</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -2 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
SCALE 1:2	ASME Y14.5M-2009
DATE 7/7/2014	USED ON MODEL
SHEET 8 OF 19	SEE NOTE 2, SHEET 1



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-3 CH'D DIM WAS 1.68 IS 1.68 ±.03.	10/15/2014	DPD	JAG
7	16-0199	-3 CH'D TITLEBLOCK TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03. CH'D DIM WAS 1.68 IS 2X 1.68, WAS .075 IS .08. CH'D MAT'L WAS 1018 IS A36/1018/1020 HR.	10/31/2016	DPD	SM

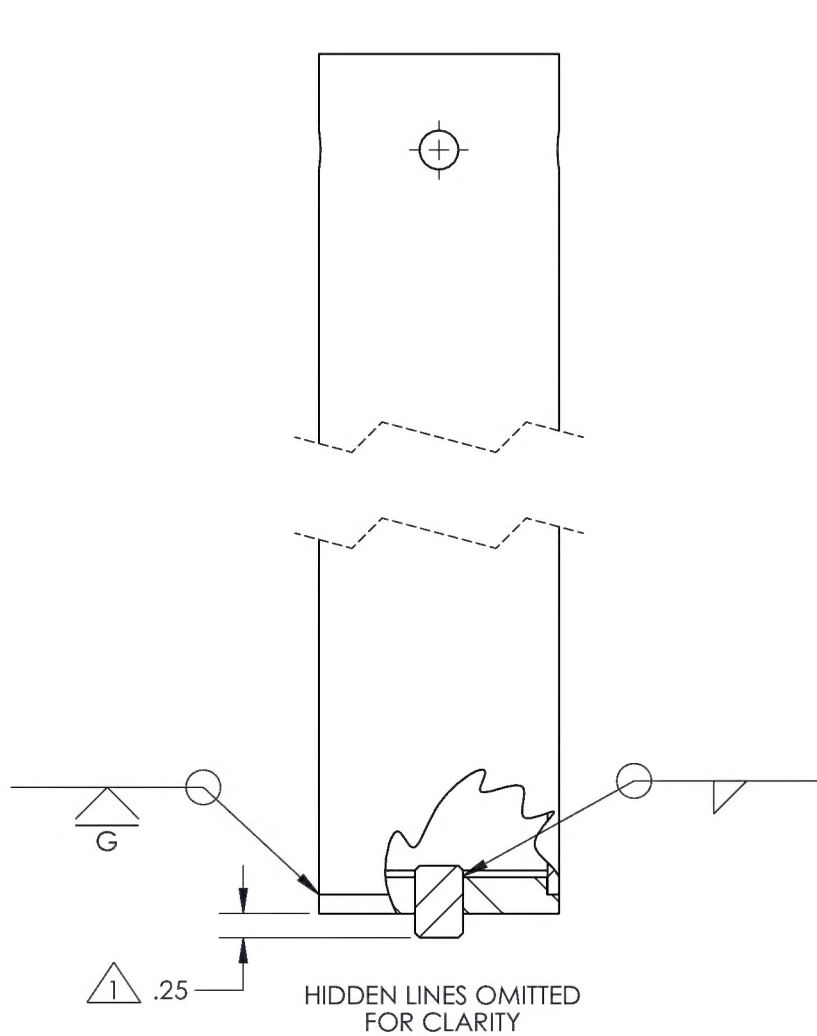


(-3)  
CLIP

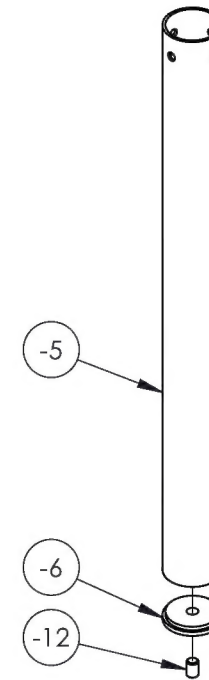
<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-3</b>	REV <b>7</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1A & -1B WELDMENTS	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE NOTE 2, SHEET 1
SCALE 1:1	DATE 7/7/2014
SHEET 9 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0199	-5A CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	11/22/2016	DPD	SM



-5A  
VERTICAL WELDMENT



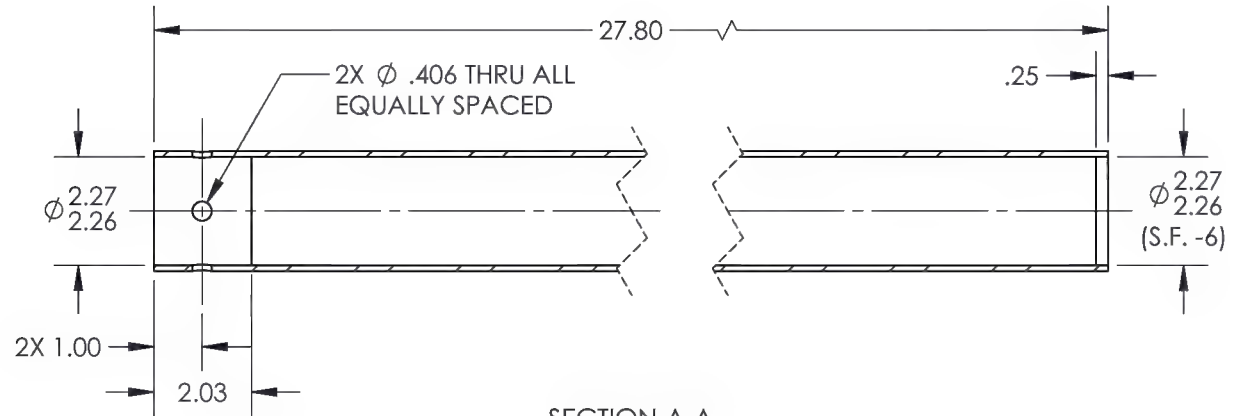
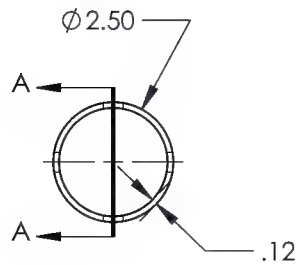
NOTE:

1 MASK BEFORE POWDER COAT.

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-5A</b>	REV <b>7</b>
MAT'L <b>STEEL</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH <b>POWDER COAT WHITE</b>	.XXX $\pm .010$ FRACTIONS $\pm 1/8$
SPEC <b>POWDER COAT WHITE</b>	.XX $\pm .03$ ANGLES $\pm 1^\circ$
DRAWN BY: <b>DUERFELDT</b>	.X $\pm .1$ SURFACES = 125
CHECKED: <b>CLOUGH</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: <b>ANDERSON</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: <b>LINDSAY</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: <b>MACKOVJAK</b>	USED ON MODEL
SCALE <b>1:2</b>	DATE <b>7/7/2014</b>
SHEET 10 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0199	-5 CH'D DIMS WAS (Ø2.50) IS Ø2.50, WAS (.120) IS .12, WAS 4X Ø.406 $\nabla$ 13 EQUALLY SPACED IS 2X Ø.406 THRU ALL EQUALLY SPACED, WAS 4X 1.00 IS 2X 1.00. ADDED DIMS Ø2.26-2.27 (S.F. -6), Ø2.26-2.27, 2.03, .25. CH'D MAT'L WAS DOM IS STEEL TUBE.	10/31/2016	DPD	SM



SECTION A-A

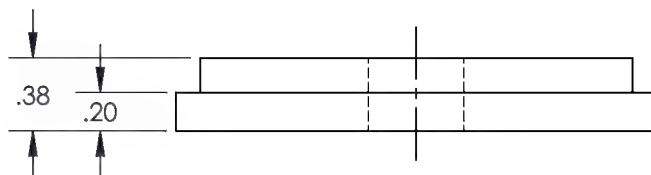
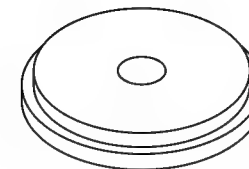
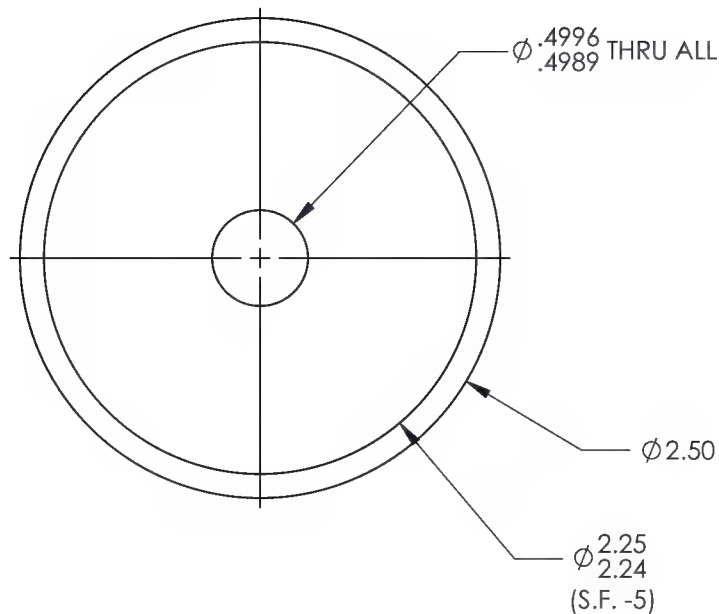
(-5)

VERTICAL TUBE

<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-5</b>	REV <b>7</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -5A WELDMENT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .01 ANGLES $\pm$ 5°
DRAWN BY: DUERFELDT	.X $\pm$ .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:4	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/7/2014	USED ON MODEL
SHEET 11 OF 19	SEE NOTE 2, SHEET 1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0140	-6 CH'D DIM WAS Ø.500 P.F. -12 IS LIMITS Ø.4989 TO .4996.	7/8/2014	DPD	JAG
7	16-0199	-6 CH'D DIMS WAS (Ø2.50) IS Ø2.50, WAS Ø2.25 S.F. -5 IS Ø2.24-2.25 (S.F. -5). CH'D MAT'L WAS 1018/1020 IS 1018/1020 CR.	10/31/2016	DPD	SM



(-6)

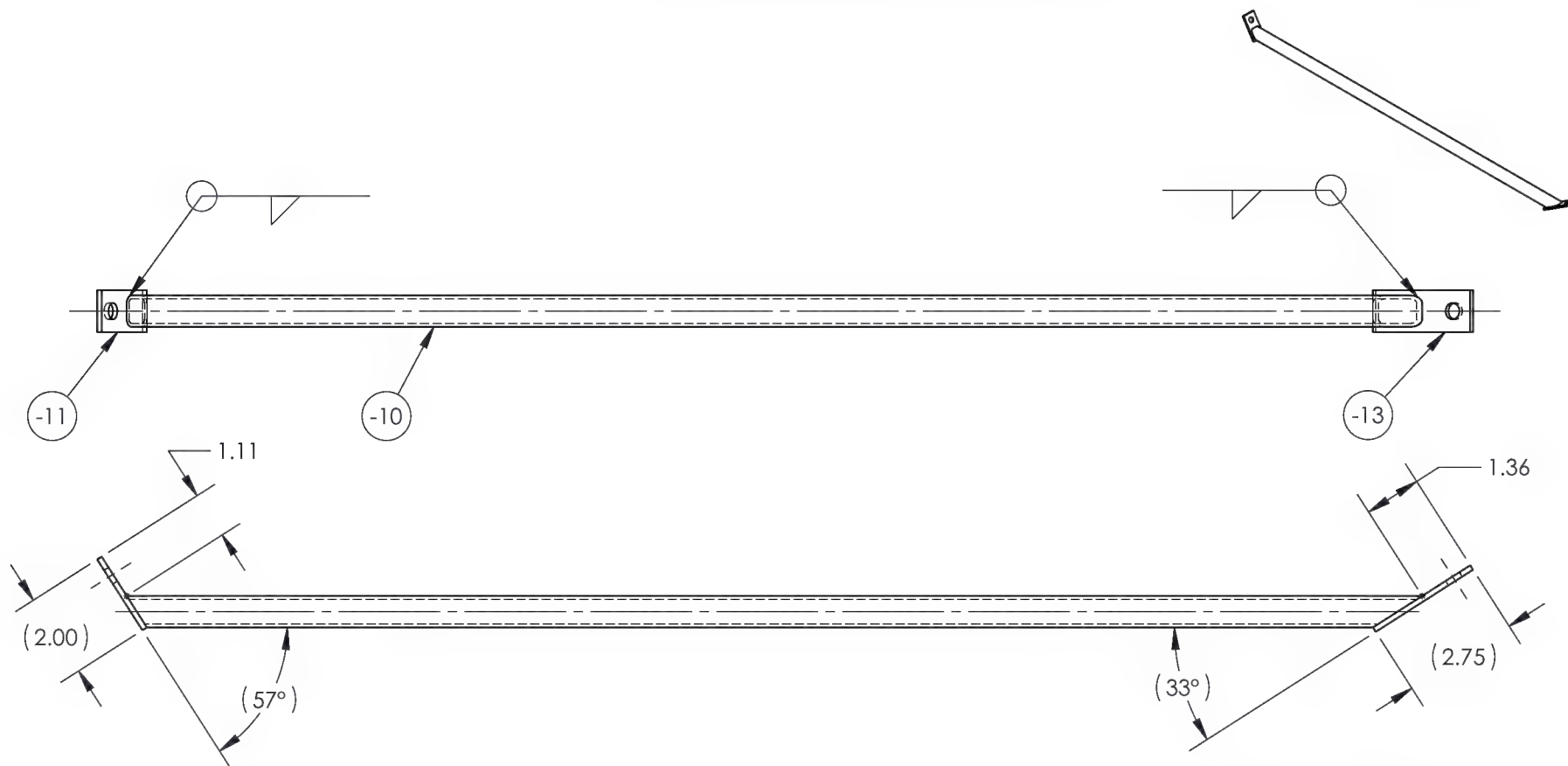
BOTTOM CAP

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-6</b>	REV <b>7</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -5A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ±.5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/7/2014	USED ON MODEL
SHEET 12 OF 19	SEE NOTE 2, SHEET 1



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-10A ADDED DIMS 1.11 & 1.36.	10/15/2014	DPD	JAG
7	16-0199	-10A CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	11/22/2016	DPD	SM



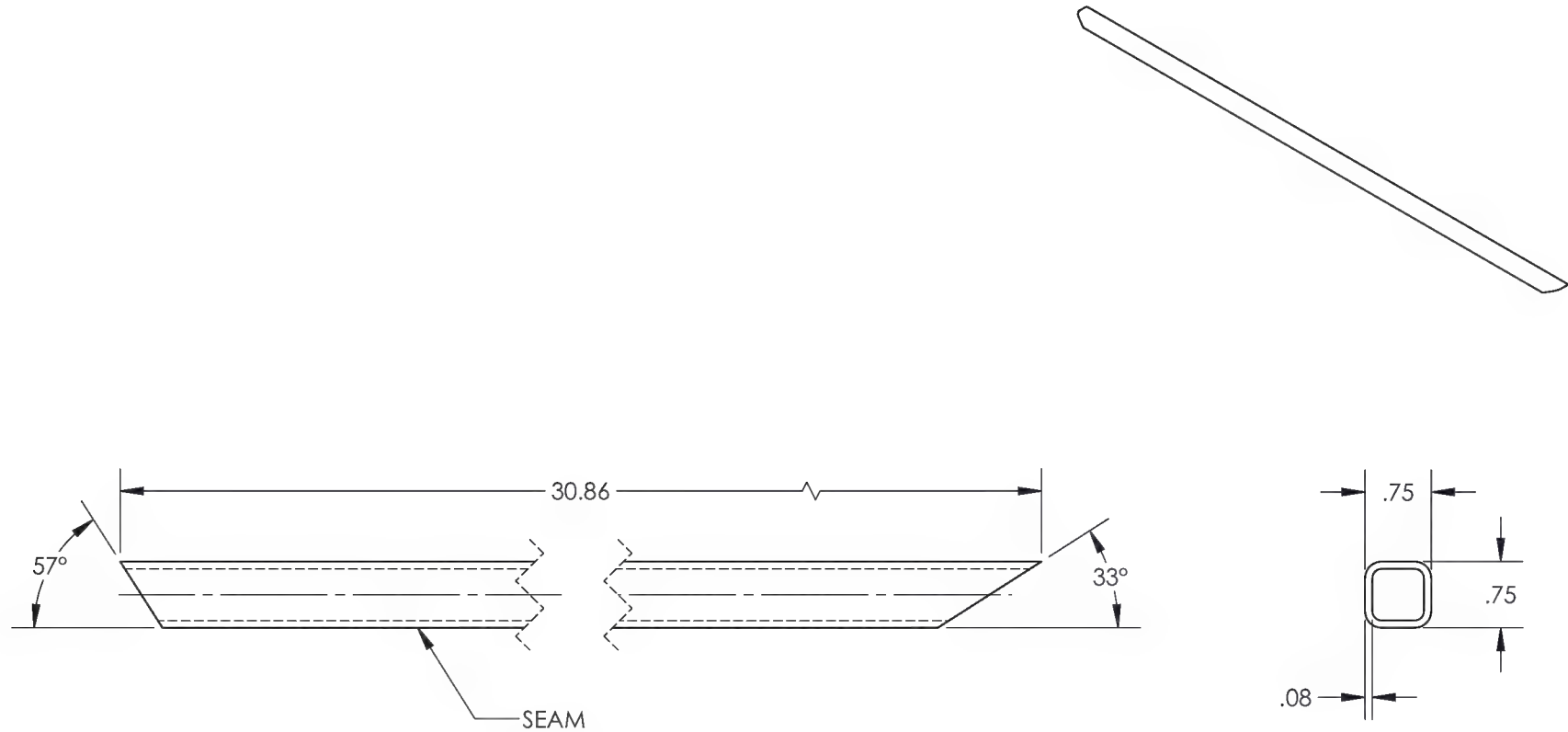
-10A

BRACE WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-10A</b>	REV <b>7</b>
MAT'L <b>6061-T6 ALUMINUM</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
FINISH <b>POWDER COAT WHITE</b>	.XX $\pm$ .03 ANGLES $\pm$ 1° .X $\pm$ .1 SURFACES = 125
SPEC <b>ASME Y14.5M-2009</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>DUERFELDT</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>CLOUGH</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	USED ON MODEL
QA APPR: <b>LINDSAY</b>	SEE NOTE 2, SHEET 1
APPROVED: <b>MACKOVJAK</b>	
SCALE <b>1:4</b>	DATE <b>7/7/2014</b>
SHEET 13 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	14-0140	CORRECTED DIM FROM 1.00 TO (.75), BOM WAS CORRECT.	8/21/2014	DPD	JAG
7	16-0199	-10 CH'D DIMS WAS (.75) IS .75, WAS (.75) IS .75, WAS (.083) IS .08. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	10/31/2016	DPD	SM



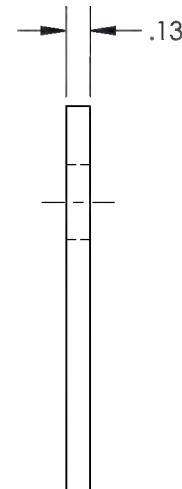
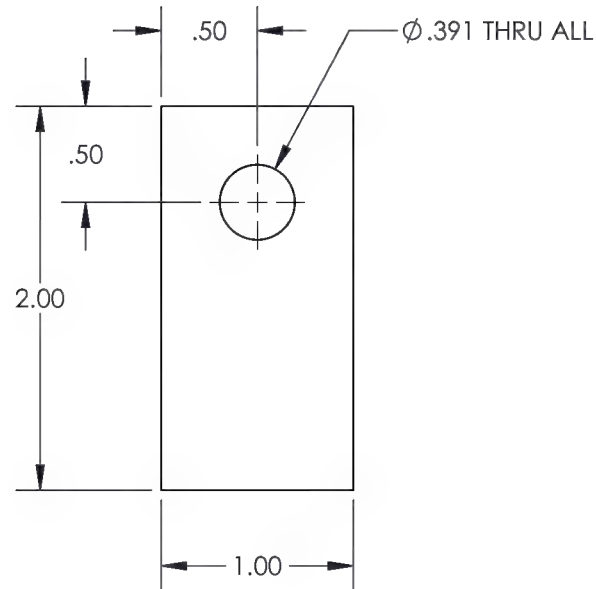
(-10)

BRACE TUBE

<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-10</b>	REV <b>7</b>
MAT'L STEEL SQ. TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
FINISH SEE -10A WELDMENT	.XX $\pm$ .03 ANGLES $\pm$ 1°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE NOTE 2, SHEET 1
SCALE 1:2	DATE 7/7/2014
SHEET 14 OF 19	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0199	-11 CH'D DIMS WAS (1.00) IS 1.00, WAS (.125) IS .13, WAS Ø.39 THRU ALL IS .391 THRU ALL. CH'D MAT'L WAS 1018 IS A36/1018/1020 HR. CH'D TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03.	10/31/2016	DPD	SM



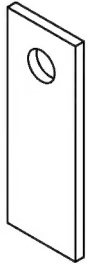
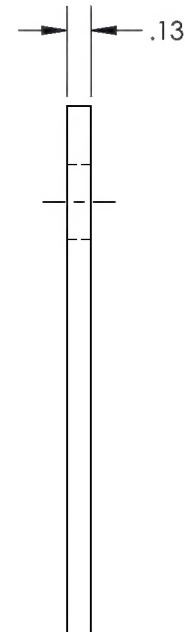
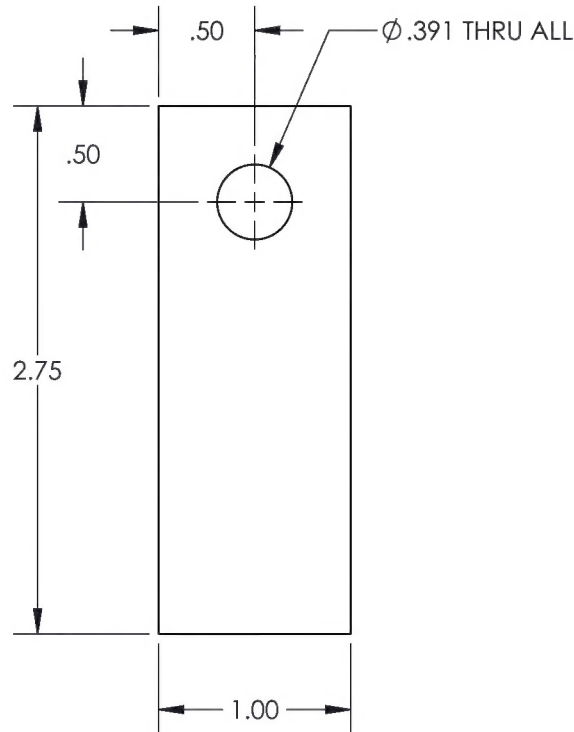
(-11)

BOTTOM BRACE TAB

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-11</b>	REV <b>7</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -10A WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 7/7/2014
	SHEET 15 OF 19

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0199	-13 CH'D DIMS WAS (1.00) IS 1.00, WAS (.125) IS .13, WAS Ø.39 THRU ALL IS Ø.391 THRU ALL. CH'D MAT'L WAS 1018 IS A36/1018/1020 HR. CH'D TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03.	10/31/2016	DPD	SM



(-13)

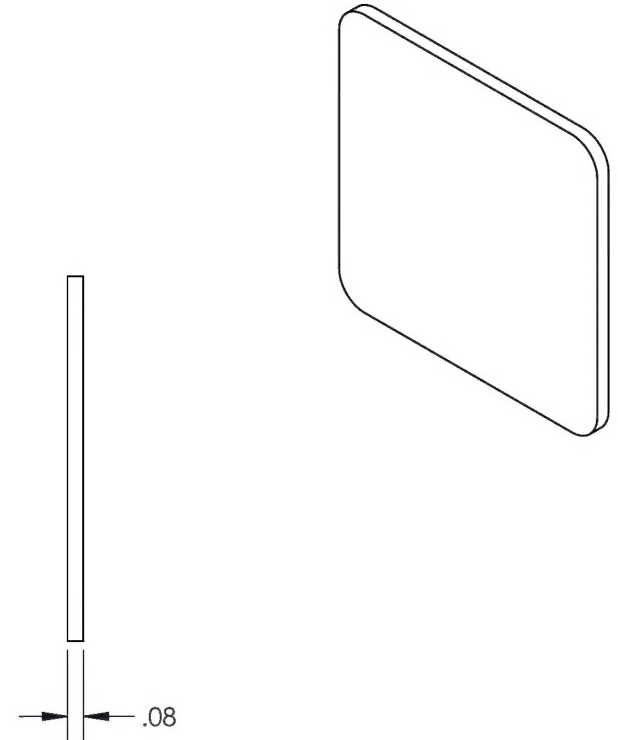
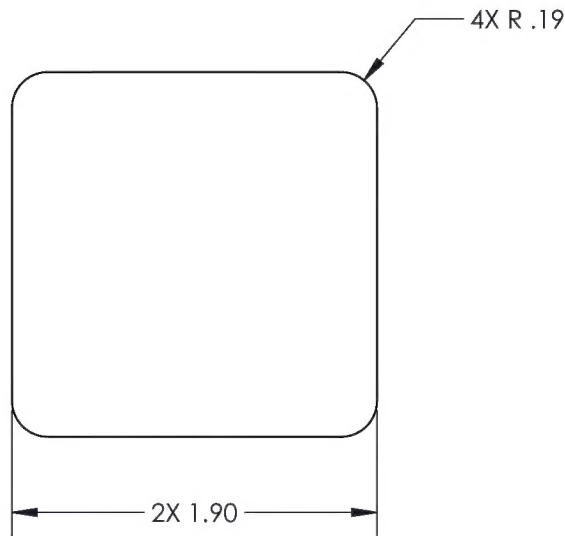
UPPER BRACE TAB

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-13</b>	REV <b>7</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -10A WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 7/7/2014
	SHEET 16 OF 19



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0178	-14 CH'D END CAP WAS B/O PLASTIC OUTWATER #T64-U-2-BLK IS IN HOUSE A36 .083 X 2-1/8 X 2-1/8, ADDED DWG.	10/14/2014	DPD	JAG
7	16-0199	-14 CH'D DIM WAS (.083) IS .08. CH'D MAT'L WAS A36 IS A36/1018/1020 HR. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	10/31/2016	DPD	SM

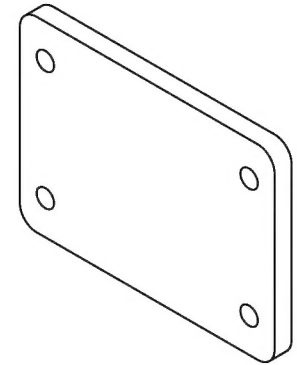
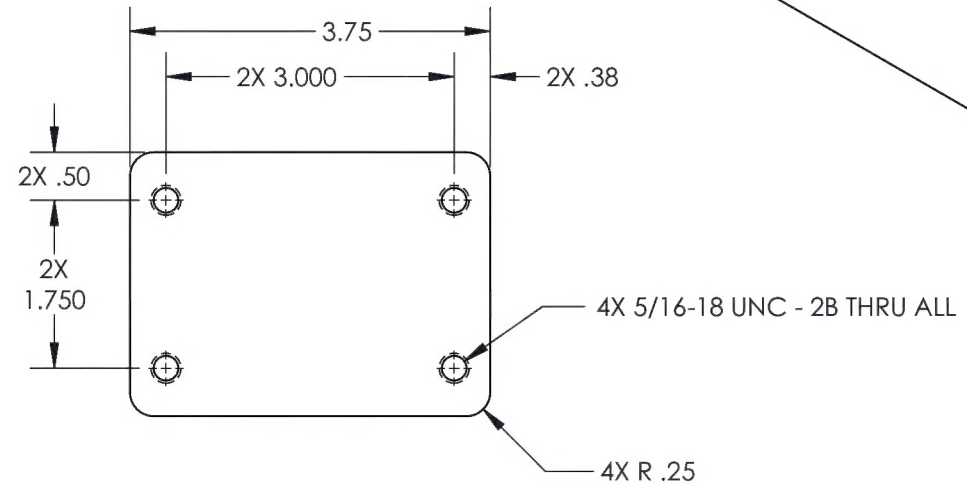
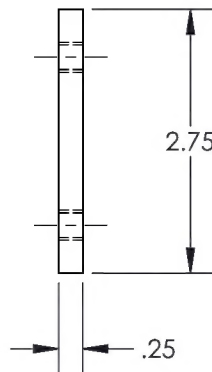


(-14)  
END CAP

<b>DART</b> AEROSPACE	
TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>	
DWG NO. <b>RBT18522-14</b>	REV <b>7</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE WELDMENTS -1A & -1B	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .03 ANGLES $\pm$ 1°
	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 9/17/2014
	SHEET 17 OF 19

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7	16-0199	-15 CH'D DIMS WAS (.250) IS .25, WAS 2X 3.00 IS 2X 3.000, WAS 2X 1.75 IS 2X 1.750, CH'D MAT'L FROM A36 TO A36/1018/1020 HR. CH'D TOLERANCES WAS $\pm .005$ IS $\pm .010$ , WAS $\pm .01$ IS $\pm .03$ .	10/31/2016	DPD	SM

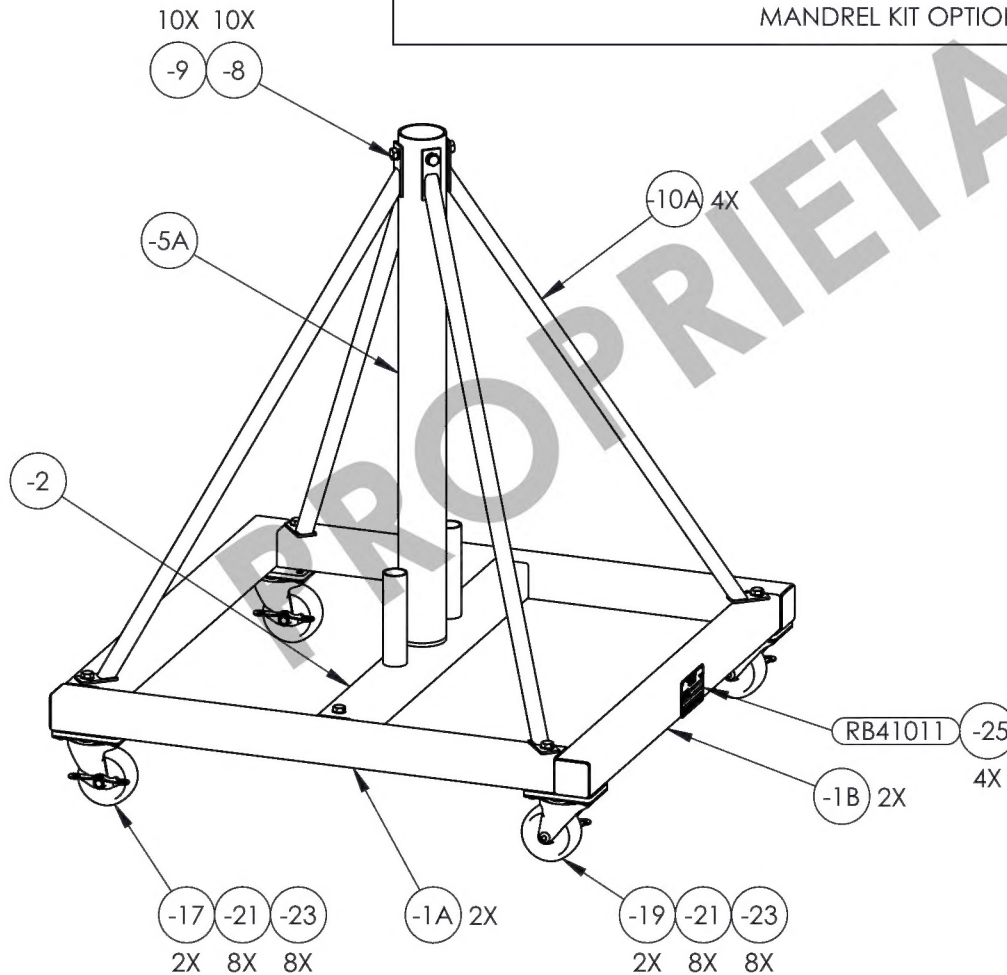
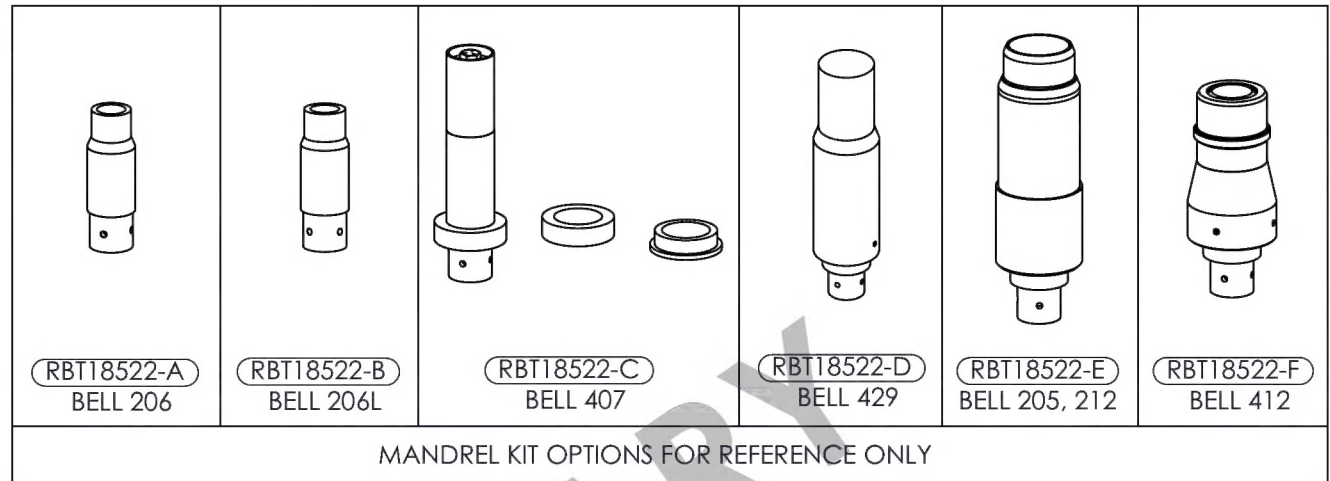


(-15)


WHEEL PLATE

<b>DART AEROSPACE</b>	
TITLE <b>ROTOR HEAD STAND</b>	
DWG NO. <b>RBT18522-15</b>	REV <b>7</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE WELDMENTS -1A & -1B	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .03 ANGLES $\pm$ 1°
DRAWN BY: GILBERT	.X $\pm$ .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 8/18/2014
	SHEET 18 OF 19

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Part #	UNIT QTY	Description
-1A	2	SIDE BASE WELDMENT
-1B	2	END BASE WELDMENT
-2	1	CENTER BASE WELDMENT
-5A	1	VERTICAL WELDMENT
-10A	4	BRACE WELDMENT
-8	10	HEX HEAD CAP SCREW
-9	10	SPLIT RING LOCK WASHER
-17	2	3 in SWIVEL CASTER W/BRAKE
-19	2	3 in RIGID CASTER
-21	16	BUTTON HEAD CAP SCREW
-23	16	INTERNAL LOCK WASHER
-25	4	#2 DRIVE SCREW
	1	PLACARD



**DART AEROSPACE**  
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dartaerospace.com

TITLE <b>ROTOR HEAD STAND ASSEMBLY</b>			
DWG NO. <b>RBT18522</b>	REV <b>7</b>	CUSTOMER 1 OF 1	
SCALE 1:10	DATE 7/7/2014	SHEET	19 OF 19